

Work Order ID 50767

July 22, 2009 6:56:06 AM

Page 1

Item ID: D3296-041

Accept

Setup Start

Revision ID: A

Stop

Item Name: Door Assembly

Start Date: 7/28/09 Start Qty: 12.00

Cust Item ID:

Required Date: 7/31/09 Req'd Qty: 12.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3296

Rev A

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Fabricate & assemble as per Dwg D3296.

Transfer drill using DT8470 & DT9521

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

120

0.00



Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

Powdercoat

Memo

0.00

Powder Coating

START TIME: 11:15pm

OVEN TEMPERATURE:

320°F FINISH TIME:

11:45pm

9/1 09/08/20

09/08/20

12

2) 09/08/20

12

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

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Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Eff 09/08/26. (12)

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3296

Eff 09/08/26 (12)

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

27 8 09/08/26

(12)

φ

W/O:		WORK ORDER CHANGES					
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Setup Start



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Cust Item ID:

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Picklist Print

July 22, 2009 6:56:06 AM

Work Order ID: 50767

Parent Item: D3296-041 RevA

Parent Item Name: Door Assembly


Comments:

Start Date: 7/28/09

Required Date: 7/31/09

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD6  Washer		Purchased	No			140	Each	1,573.000	12.0000			

Ep 09/08/20

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

1573

104537

1114

6085

459

Manufactured No

140

Each

18.0000

12.0000

Ep 09/08/20

D2137



Decal - No Step

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

18

108012

6

45851

1

48527

10

Manufactured No

140

Each

3.0000

12.0000

Ep 09/08/20

D2419 RevA



Handle

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

3

48529

3

AB51173

3
9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D3296-041RevA

Parent Item Name: Door Assembly



Comments:

Start Date: 7/28/09

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Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2462RevA1		Manufactured	No			140	f	795.0000	3.9996			
												
Seal												

Ep 09/08/26

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

37747

Main Warehouse

ST404

48530

2 Door = 7.9992

-5

-5

800

800

39.996

D2728-1RevB Manufactured No



Dart Logo label

D3161-7RevA2 Manufactured No



Hinge 14.0"

140 Each 0.0000 0.0000

100 Each 12.0000 12.0000

Ep 09/08/20

Ep 09/08/20

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

45842

12

12

100 Each 0.0000 12.0000

12

D3161-9RevA2 Manufactured No



Hinge 17.0"

Ep 09/08/20

B51174 (12x)

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Shop Packet Print

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: Door Assembly



Comments:

Start Date: 7/28/09

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3296-1RevA		Manufactured	No			100	Each	6.0000	12.0000			
												
Door Panel												




Ep09/08/20

Warehouse
Location
Main Warehouse
ST
47694

Loc Qty

Loc Code

B50765 *(2)*

D3296-3RevA		Manufactured	No			100	Each	0.0000	12.0000			
												
Door Panel												
MS20470AD4-4		Purchased	No			140	Each	2,782.000	300.0000			
												
Rivet, Universal Head												

Ep09/08/20

Ep09/08/20

Warehouse
Location
Main Warehouse
ST
110427
111359

Loc Qty

Loc Code

2782
-476
3258

300

July 22, 2009 6:56:06 AM

Shop Packet Print

Page 3

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20470AD4-6		Purchased	No			100	Each	1,317.000	12.0000			
												
Rivet, Universal Head												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1317

109371

64

110915

1253

EF 09/08/20

12

July 22, 2009 6:56:06 AM

Shop Packet Print

Page 4

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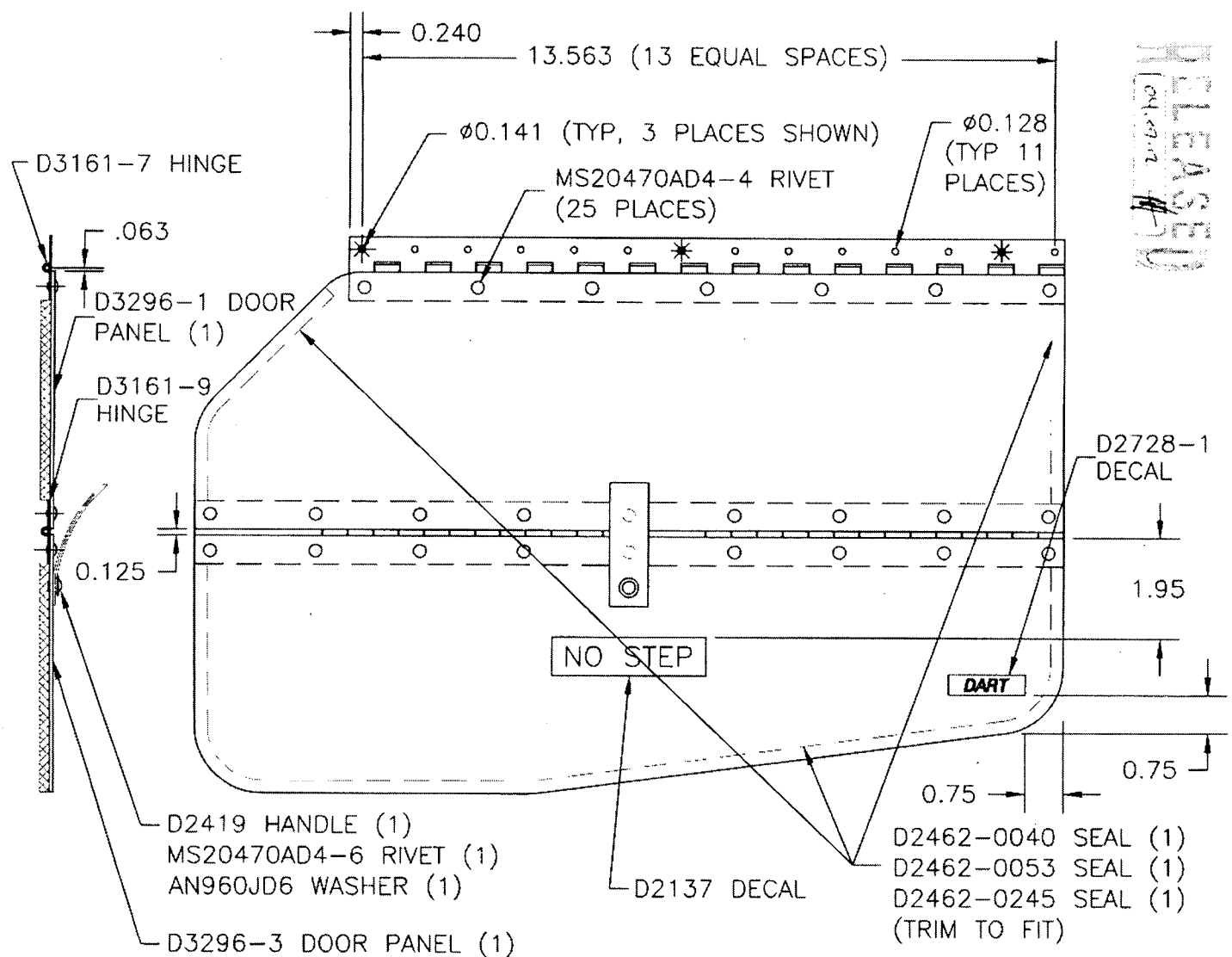
40 50767

DART



RELEASED
04.06.28

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3296
DATE 04.06.28	TITLE DOOR ASSEMBLY	REV. A 1 OF 2
A	04.06.28	SCALE 1:3
	NEW ISSUE	



D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

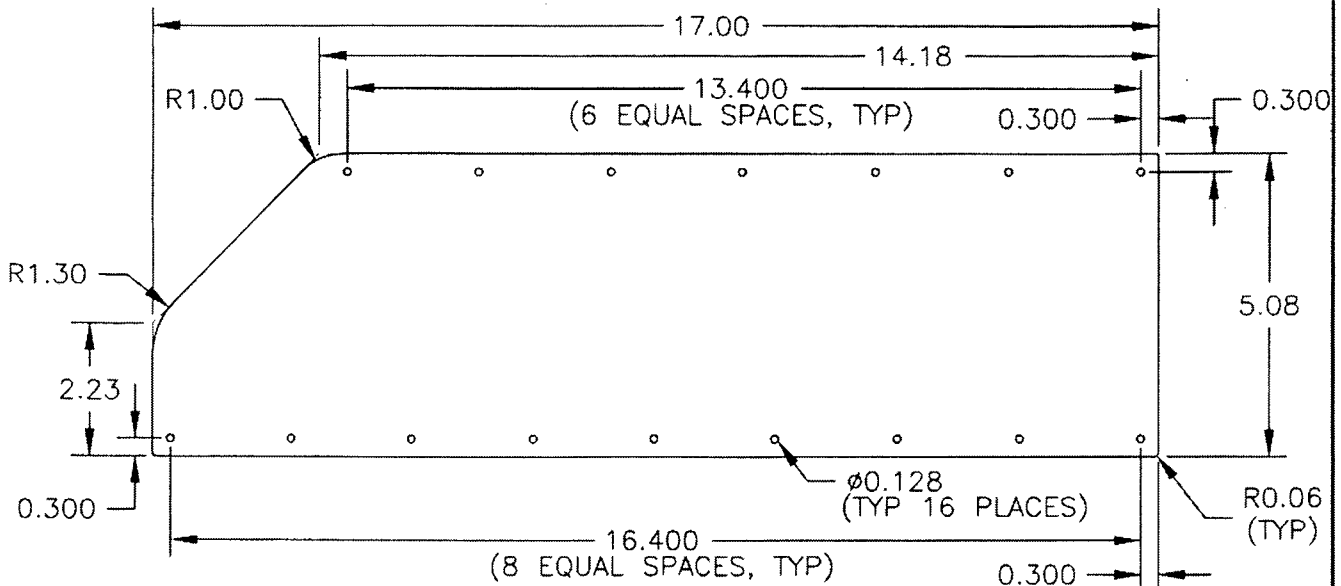
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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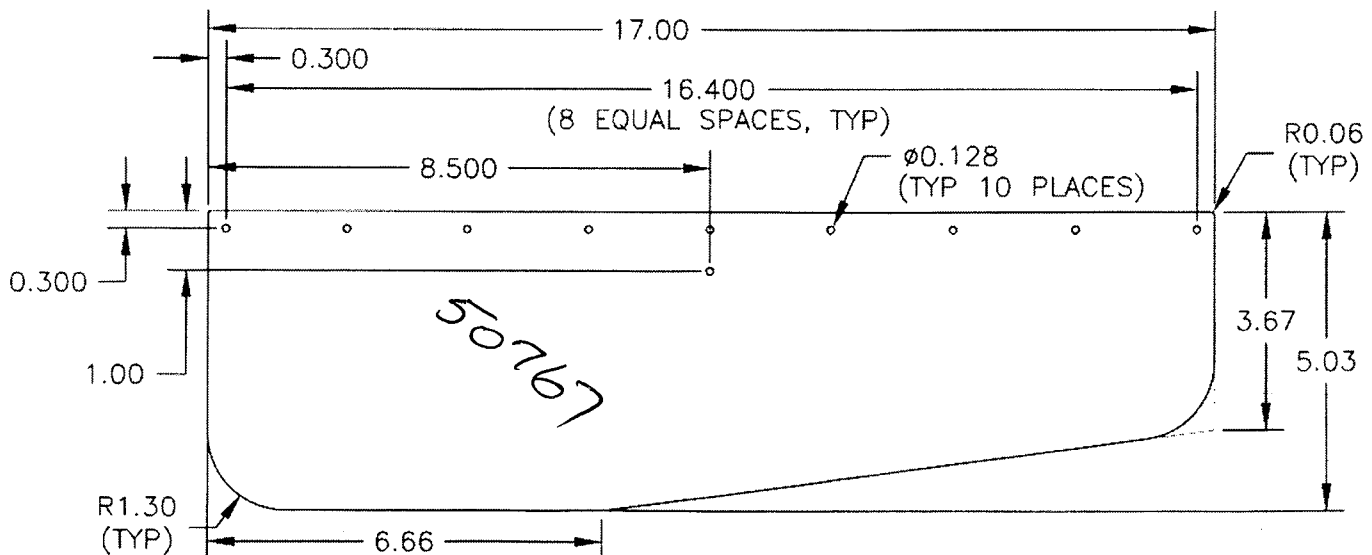
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

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